

Grey

Dart Aerospace Ltd.

Date: Monday, 27/04/2009 12:51:27 PM  
User: Julie Dawson

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	WEARSHOE
<b>Job Number</b> :	47537		
<b>Estimate Number</b> :	13310		
<b>P.O. Number</b> :		<b>Part Number</b> :	D37931
<b>This Issue</b> :	27/04/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3793 REVA
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	47024	<b>Drawing Revision</b> :	A
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	JUD 09.04.27	<b>Due Date</b> :	07/05/2009
<b>Comment</b> :	Est Rev:A 08-05-13 new issue DD verified by:EC Est Rev:B 08-05-23 revA as per dwg DD verified by:EC		
		<b>Qty:</b>	12 Um: Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S20GA	304/316 .040 Sheet
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**Comment:** Qty.: 0.6197 sf(s)/Unit Total : 7.4365 sf(s)  
304/316 .040 Sheet  
(M304S20GA)  
Batch: 111571 HB 94-30

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
1-Cut as per Dwg D3793  
Dwg Rev: A  
Prog Rev: A

HB 9-4-30

13

2-Deburr if necessary HB 9-4-30

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

HB 9-4-30

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 09/05/01 KB

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE  
1-Deburr if necessary

2-Form on Brake as per Dwg D3793 using Jigs

SB 09/05/01

B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 27/04/2009 12:51:27 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 47537

Part Number: D37931

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Form Joggle on brake using Jig as per Dwg D3793

SB 09/05/03 (B)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/05/04 (X13)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

MM 109091

START TIME:

8:35

OVEN TEMPERATURE:

320

FINISH TIME:

9:05

BR 09-05-5 (B)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-01 (B)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP. 18

BR 09-05-5 (B)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/05 JF

Job Completion



MF 09-05-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 47537
<b>Description:</b> Wearshoe		<b>Part Number:</b> D3793-1
<b>Inspection Dwg:</b> D3793	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

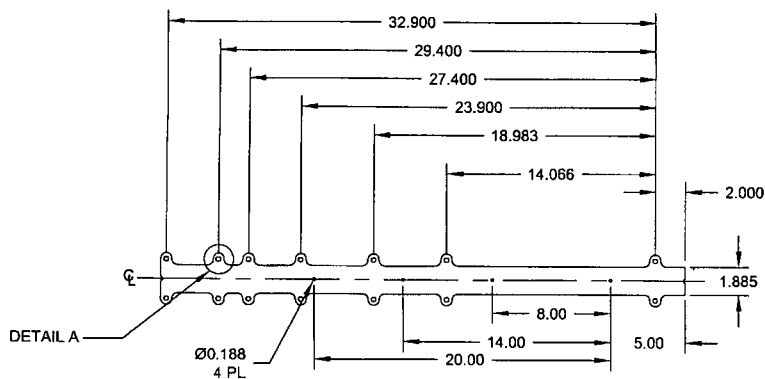
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	.188	*			
0.300 x 0.300	+/-0.010	300x300	*			
1.885	+/-0.010	1.888	*			
2.000	+/-0.010	2.000	*			
5.00	+/-0.030	5.00	*			
8.00	+/-0.030	8.00	*			
14.00	+/-0.030	14.00	*			
20.00	+/-0.030	20.00	*			
14.066	+/-0.010	14.066	*			
18.983	+/-0.010	18.983	*			
23.900	+/-0.010	23.900	*			
27.400	+/-0.010	27.400	*			
29.400	+/-0.010	29.400	*			
32.900	+/-0.010	32.900	*			
0.040	+/-0.010	.037	*			

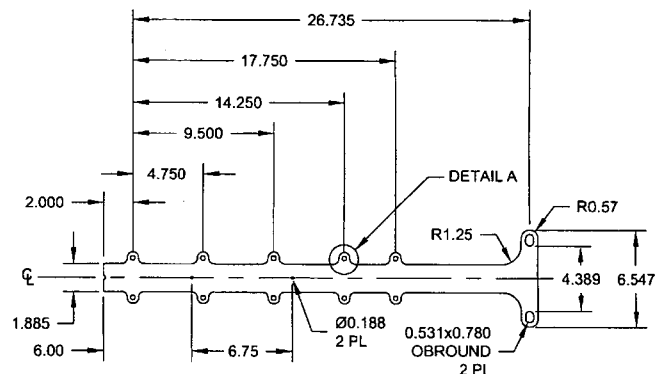
<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 9-4-30	<b>Date:</b> 09/05/01	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	

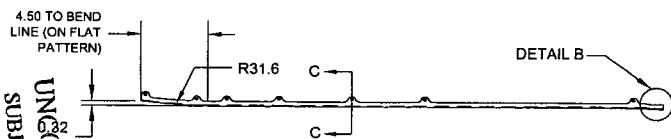
8 7 6 5 4 3 2 1



**D3793-1F FLAT PATTERN**



**D3793-3F FLAT PATTERN**



**D3793-1 BEND DETAIL**  
(MAKE FROM D3793-1F)



**D3793-3 BEND DETAIL**  
(MAKE FROM D3793-3F)

**RELEASED**  
28-05-23/18

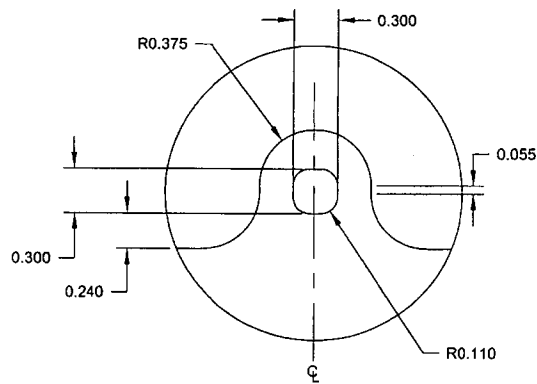
**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

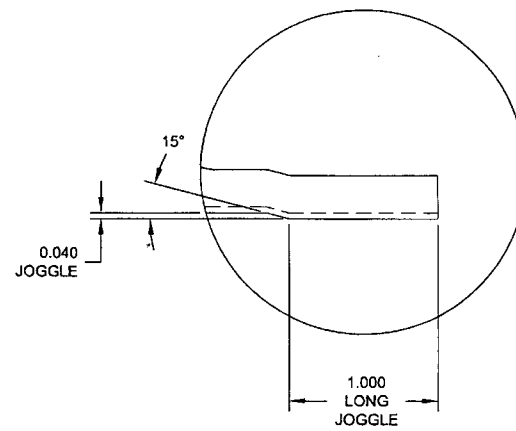
REV.	NEW ISSUE	DESCRIPTION	PH	08.05.14
DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	BY	DATE
DRAWN	PH	PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3793	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		WEARSHOE	NTS	
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8 7 6 5 4 3 2 1

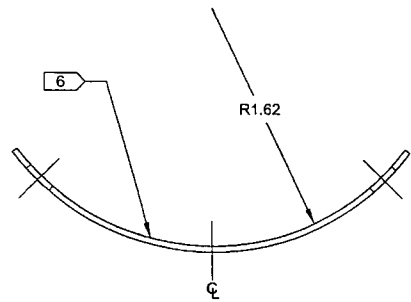
8 7 6 5 4 3 2 1



**DETAIL A**  
SCALE 10X



**DETAIL B**  
SCALE 10X



**SECTION C-C**  
SCALE 10X

**RELEASED**  
08-05-23 1188

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CHECKED		DRAWING NO.	REV. A
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8 7 6 5 4 3 2 1